

Date: Tuesday, 1/10/2006 11:10:26 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 25418	Part Number	: D34581
Estimate Number	: 11412	Drawing Number	: D3458 REV.A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 1/10/2006 S.O. No. : N/A	Drawing Revision	: A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 1/14/2006
Previous Run	: 25209	Qty:	24
Written By	: See comment below	Um:	Each
Checked & Approved By	: See comment below		
Comment	: est. REV. A 05.12.13 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0187X04000	6061-T6 Bar..178" x 4.0"
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Comment: Qty.: 0.7437 f(s)/Unit Total : 14.8743 f(s)

ALUMINUM 6061-T6 Bar..188" x 4.0"

Batch: 17834 (6)

SA 06.01.10

6

2.0	SHEAR	SHEAR
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Comment: SHEAR

cut blanks 8.500" long

SA 06.01.10

6

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA604 rev: A & dwg D3458 rev. A

1 blank makes 4 parts

SA 06.01.10

24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.01.10

24

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

BG 06.01.11

24

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr parts per dwg D3458

DL 06/01/13

24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/10/2006 11:10:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 25418

Part Number: D34581

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 01.150

24

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

Job 01.26

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Sut 06/01/17 (24)

06/01/17 (24)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

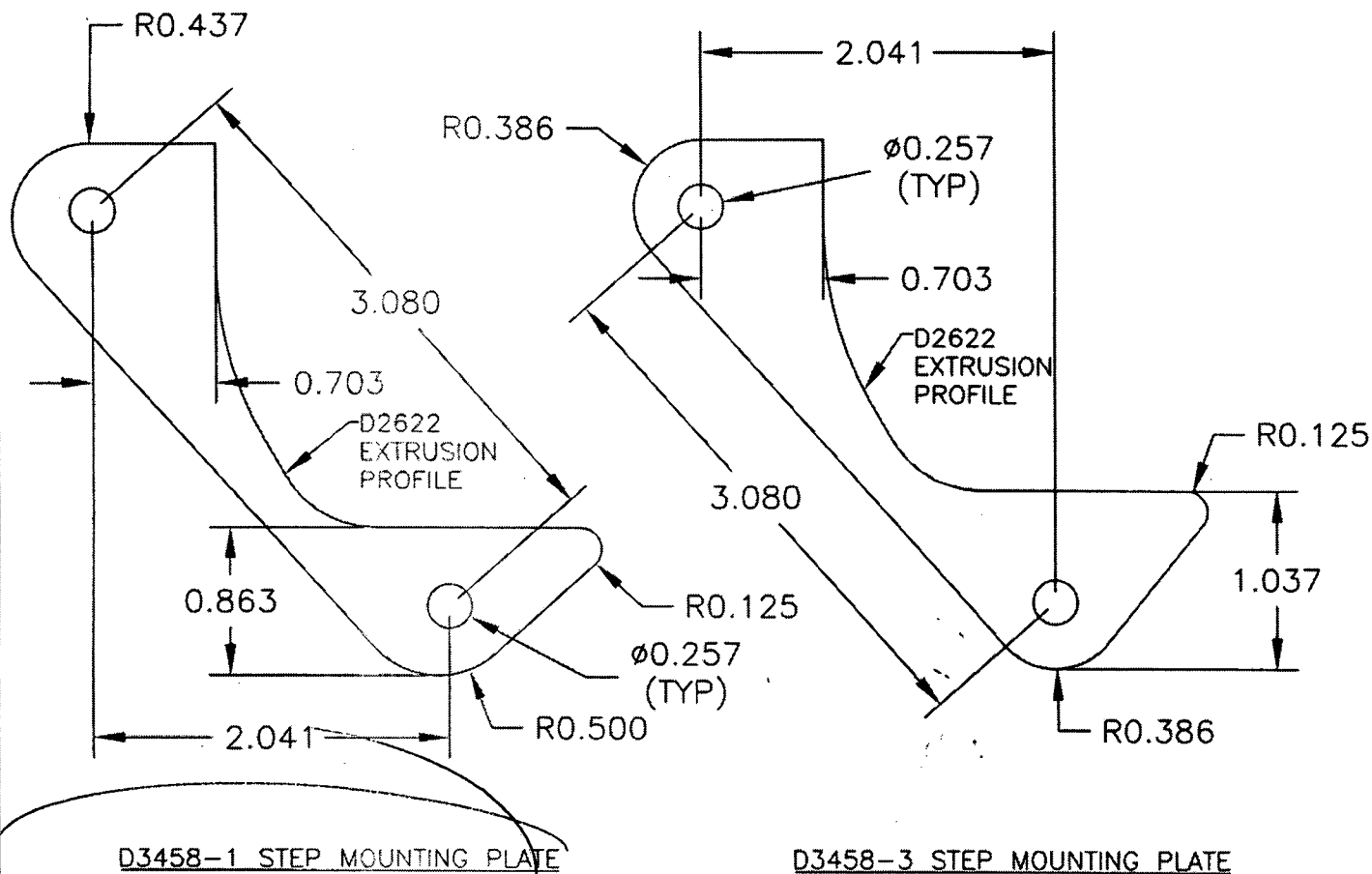
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3458	REV. A
DATE 05.09.23		TITLE STEP MOUNTING PLATE	SHEET 1 OF 1
A	05.09.23	NEW ISSUE	SCALE 1:1



D3458-1/-3 STEP MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Peter Hum

From: David Shepherd [davids@dartaero.com]
Sent: Tuesday, January 10, 2006 6:28 PM
To: Peter Hum
Subject: Re: D3458-1 PLATE chipped

Peter,

It is acceptable to buff out this damage and salvage the parts as the damage is in a low stress area.

David

----- Original Message -----

From: "Peter Hum" <phum@dartaero.com>
To: "'David Shepherd'" <davids@dartaero.com>
Sent: Tuesday, January 10, 2006 3:29 PM
Subject: RE: D3458-1 PLATE chipped

> David,
>
> The length of the chip is 0.250" and 0.020" deep at the apex of the curve
> point (worst cased)

> Peter

> -----Original Message-----

> From: David Shepherd [mailto:davids@dartaero.com]
> Sent: Tuesday, January 10, 2006 5:20 PM
> To: Peter Hum
> Subject: Re: D3458-1 PLATE chipped

> Peter,

> Please re-send your request, telling me how deep the chip is and over what
> length. Then I will respond.

> David

> ----- Original Message -----

> From: "Peter Hum" <phum@dartaero.com>
> To: "David Shepherd (E-mail)" <davids@dartaero.com>
> Sent: Tuesday, January 10, 2006 2:47 PM
> Subject: D3458-1 PLATE chipped

> > Hi David,

> >
> > These came off the CNC machine, in the circled section the part is
chipped

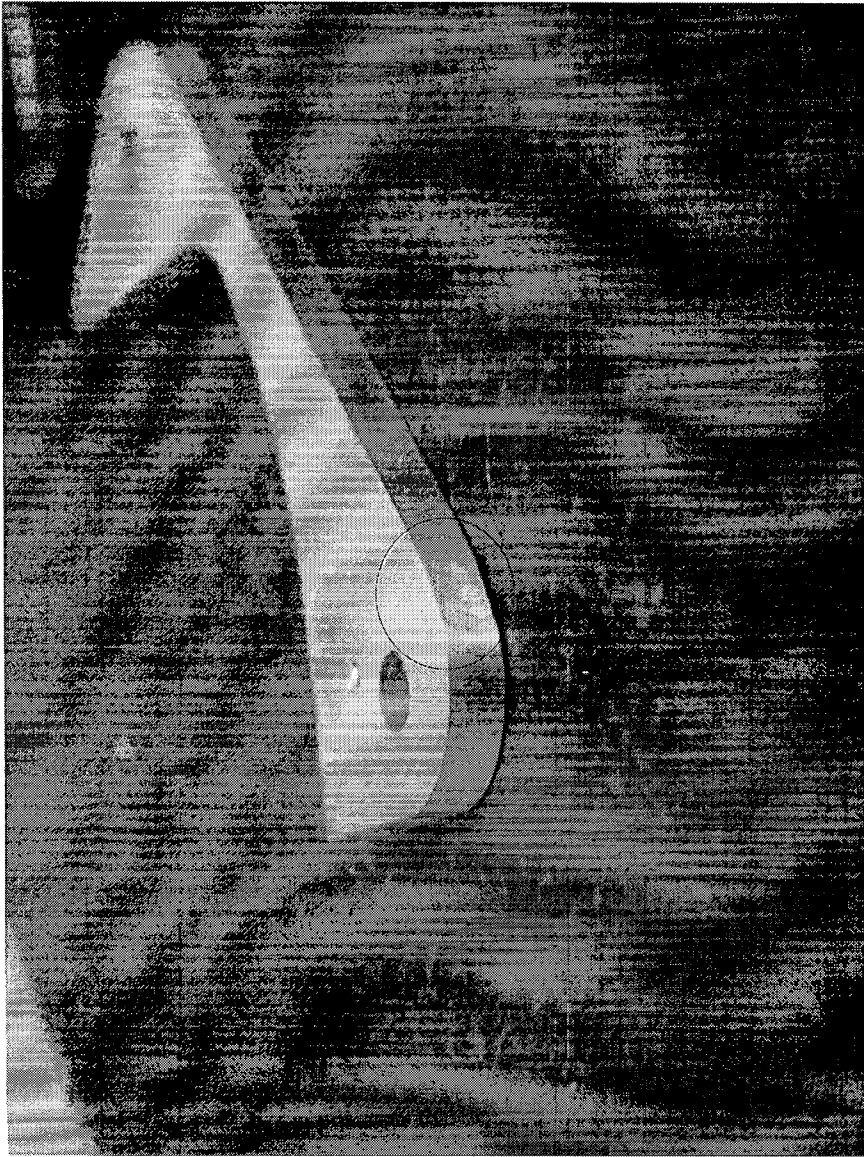
> > because of the machining process, there is a small amount of material
> > missing. This is only on 6 of 24. There is still a lot of material
present

> > Is it acceptable to buff these parts to smooth out the finish?

> > Peter Hum

> > Mechanical Designer

> >



2. 4